



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2530

Job Sheet 188199



Part No: D2530

Job Qty: 8 pcs

Part Name: Handle Weldment



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/4/19

Job Tracking No:

Due Date: 1/18/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev:E Removed Purchasing 05-11-07 JLM IPP Rev:F 11.01.07 chg qc 5 to 6 DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Welded Assy-1	8 pcs	1/18/19	0.12	1.55		Large Fab - 1		ABC
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
110	QC 5	8 pcs	1/18/19	0.00	0.00		QC 5 - 10		A
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
120	Large Fab - Welded Assy-2-B4B	8 pcs	1/18/19	0.00	3.20		Large Fab - 1 - B4B		ABC
							Large Fab - 10 - B4B		
							Large Fab - 2 - B4B		
							Large Fab - 3 - B4B		

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

				Large Fab - 4 - B4B	
				Large Fab - 5 - B4B	
				Large Fab - 6 - B4B	
				Large Fab - 7 - B4B	
				Large Fab - 8 - B4B	
				Large Fab - 9 - B4B	
130 QC 9	8 pcs	1/18/19	0.00 0.00	QC 9 - 10	
				QC 9 - 18	
				QC 9 - 24	
				QC 9 - 43	
				QC 9 - 50	EL
				QC 9 - 9	
140 QC 5	8 pcs	1/18/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 38	
				QC 5 - 42	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	EL
				QC 5 - 30	
150 Powdercoat - 4 Black Sand -B4B M138940	8 pcs	1/18/19	0.00 0.30	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	BR 19-03-H
				Powdercoat - 4 - B4B	
				START 10:10 A.T. 300 FINISH: 10:40	
160 QC 3	8 pcs	1/18/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 26	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 38	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 6	
				QC 3 - 68	
				QC 3 - 9	
170 Packaging 3-1 - Stock - B4B	8 pcs	1/18/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	FP001
				Packaging 3 - 5 - B4B	MAR 21 2019
				Packaging 3 - 6 - B4B	

DAS
40
9-89
MAR 15 2019

Entered: _____ Date: _____



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Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

		Packaging 3 - 7 - B4B					
		Packaging 3 - 8 - B4B					
		Packaging 3 - 9 - B4B					
		Packaging 3 - 10 - B4B					
		Packaging 3 - 11 - B4B					
		Packaging 3 - 12 - B4B					
		Packaging 3 - 13 - B4B					
		Packaging 3 - 14 - B4B					
		Packaging 3 - 15 - B4B					
		Packaging 3 - 16 - B4B					
		Packaging 3 - 17 - B4B					
		Packaging 3 - 18 - B4B					
		Packaging 3 - 19 - B4B					
		Packaging 3 - 20 - B4B					
		Packaging 3 - 21 - B4B					
		Packaging 3 - 22 - B4B					
		Packaging 3 - 23 - B4B					
		Packaging 3 - 24 - B4B					
		Packaging 3 - 25 - B4B					
		Packaging 3 - 26 - B4B					
		Packaging 3 - 27 - B4B					
		Packaging 3 - 28 - B4B					
		Packaging 3 - 29 - B4B					
		Packaging 3 - 30 - B4B					
		Packaging 3 - 31 - B4B					
		Packaging 3 - 32 - B4B					
		Packaging 3 - 33 - B4B					
		Packaging 3 - 34 - B4B					
		Packaging 3 - 35 - B4B					
		Packaging 3 - 36 - B4B					
		180 QC 21 - SA	8	1/18/19	0.00 0.00	QC 21 - SA - 21	DAS 21 MAR 21 2019
			pcs			QC 21 - SA - 70	9-69
		Part Op 100 - (Fabricate per Drwg) 1-Cut to length as per Dwg D2530					
		Descriptions: 110 - (QC5- Inspect part completeness to step on W/O)					
		120 - 1-Weld as per Dwg D2530 and QSI 004 using Welding Jig DT8301					
		130 - (QC9- Inspect visual per QSI004- Fusion Welds)					
140 - (QC5- Inspect part completeness to step on W/O)							
150 - (Black Sandtex(Ref:4.3.5.7) per QSI005 4.3) START TIME: _____ FINISH TIME: _____							

Entered: _____ Date: _____



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Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		
Other/Details:				

160 - (QC3- Inspect Part Finish)

170 - (Identify as per dwg & Stock Location: _____)

180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304TR0.750W.049	304 Round Tube .750 X .049W	23.3160 ft (2.9145 ea)	100-Large Fab - Welded Assy-1	
D2534	Lock Plate	16 pcs (2 ea)	120-Large Fab - Welded Assy-2- B4B	

10 *S157001; 6- S155185*

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	M304TR0.750W.049	23	137	0
120-Large Fab - Welded Assy-2- B4B	D2534	16	1	0

Part Specifications

Specifications could not be found.

Plex 1/4/19 11:26 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



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Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
1270 Aberdeen Street Hamlet, NY 14077 CANADA TEL: 1 513 632-5200 Email: sales@dartaero.com www.dartaero.com Date: 03/13/19 Container No: S161841 Part: D2530 Job No: 188199 Serial No/Batch: S161841 Revision: Inspector: Exp Date: Instructions: Various STC's			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Open _____ Manufacturing Process _____ Equipment _____ Handling/Preservation _____ Material _____ Product Improvement _____ Process Improvement _____ Human Factors ☐ Other Details: _____			Power Loss/Surge _____ Welding/Program _____ Weld Direction _____ Weld _____ Wrong Stock Pulled _____ Out of Sequence _____ Off-set/Set-up _____ ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		